



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBH9928-1-1
Job Sheet 168649



Part No: RBH9928-1-1

Job Qty: 3 ea *11*

Part Name: Gage



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/21/17

Job Tracking No:

Due Date: 12/4/17

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBH9928-1 Rev 10 U/R IPP Rev A 17.11.13 New issue DP Verify DD/IPP Rev B 17.11.20 DWG REV A DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	3 Ea		12/2/17	0.00	0.00	Start Up Machining		<i>MS 18/01/21</i>
110	Mori Seiki	3 pcs		12/4/17	0.00	3.00	MORI NV5000-2		<i>MS 18/01/21</i>
120	QC	3 pcs		12/4/17	0.00	0.00	QC2		<i>MS 18/01/21</i>
130	QC	3 pcs		12/4/17	0.00	0.00	QC8		
140	Packaging	3 pcs		12/4/17	0.00	0.00	Packaging3 <i>6A</i>		<i>AT 18/01/22</i>
150	QC21-SA	3 Ea		12/4/17	0.00	0.00	QC21		

Part Op 110 - 1-Machine as per folio FB *675* FOLIO REV: _____ DWG REV: _____ 2-Deburr ***PVC
Descriptions: used is grey. Need engineering sign off***

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	8740K75	3	0	0	0

Part Specifications

Specifications could not be found.

SD16459 → SD34057

Plex 11/21/17 7:30 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

DART AEROSPACE LTD		Work Order: 168649
Description: GAGE		Part Number: RBH9928-1-1
Inspection Dwg: RBH9928 Rev: A		Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.88	± 0.30	4.875	—		Vern H-L-08	
3.56	± 0.30	3.560	—		"	
R.25	± 0.30	R.250	—		R-G	
10.31	± 0.30	10.312	—		Vern H-L-08	
R.28	± 0.30	R.280	—		R-G	
R.25	± 0.30	R.250	—		"	
.88	± 0.30	.880	—		Vern H-L-08	
2.50	± 0.30	2.502	—		"	
10°	± 1/2°	10°	—		C-Square	
R.28	± 0.30	R.280	—		R-G	
45°	± 1/2°	45°	—		C-Square	
2.38	± 0.30	2.395	—		Vern H-L-08	
.50	± 0.30	.500	—		"	
1.00	± 0.30	1.007	—		"	
0.375	± 0.05	0.376	—		"	
3.45	± 0.30	3.450	—		"	
2.54	± 0.30	2.540	—		"	
.28	± 0.30	.280	—		"	
.75	± 0.30	.740	—		"	
2.00	± 0.30	2.010	—		"	
.52	± 0.30	.520	—		"	
45°	± 1/2°	45°	—		"	
.52	± 0.30	.520	—		"	
.75	± 0.30	.730	—		"	
.38	± 0.30	.376	—		"	

Measured by: JH	Checked by: [Signature]	QC Inspector:
Date: 18/01/21	Date: 18-01-22	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	

DQA: _____ Date: _____

WORK ORDER NON CONFORMANCE / UPDATE



QA Clo

Work

DART
AEROSPACE
S034058

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Work Order update only ☐

AGAINST DEPARTMENT/PROCESS

Cross tube	☐	Water Jet	☐	Engineering	☐
Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
Finishing	☐	Rec/Store/Packaging	☐	Other	☐
Composite	☐	Supplier	☐		

Date:

Gage

PART NO: RBH9928-1-1**Original Serial #: S034058****Revision:****Operation: Start up Operation 01/22/18****Change No:****Job No: 168649**

Disposition

MRB (QSI042) Approval

Completed By

Lead hand / Supervisor
Approval VerificationQC / QA Coordinator
Approval

Root Cause

Environment	☐	No Re-verification	☐
Design	☐	Operator	☐
Doc/Data	☐	Offset/Setup	☐
Equip/Tooling	☐	Supplier	☐
Handling/Pre	☐	Training	☐
Material	☐	Use for Testing	☐
Internal Transport	☐	Poor Information	☐
Tribal Knowledge	☐	Rushing	☐
LOA	☐	Product Improvement	☐
Substation	☐	Process Improvement	☐
Past Expiry Date	☐	Manufacturing Process	☐
Misidentified	☐	Past Due	☐

Pressure/Forced	☐
Bending	☐
Centre Not Concentric	☐
Cracks	☐
Crimp/Kink/Ripple/Wave	☐
Cuffs	☐
Crushing	☐
Heat Treat	☐
Wave/Twist in Tube	☐
Marks/Chatter	☐

FAULT CATEGORY

Temperature/Cure	☐
Set-up	☐
BOM/Route	☐
Broken/Damage/Defect	☐
Inspection Incomplete/Unqualified	☐
Contamination	☐
Countersink	☐
Cut Too Short	☐
Instructions Incomplete/Unclear	☐
Drill Holes	☐

Power Loss/Surge	☐
Folio/Program	☐
Grain	☐
Weld	☐
Wrong Stock Pulled	☐
Out of Sequence	☐
Off-set	☐
Mislabeled	☐
Fit/Function	☐
Misaligned/off center	☐

Positioned Wrong	☐
Outside Dimensions	☐
Over/Under tolerance	☐
Part Incorrect	☐
Part Lost/Missing	☐
Part Moved	☐
Drawing	☐
Finish	☐
Misread	☐
Turning Sequence	☐

OTHER :



Dart Hawkesbury
1270 Aberdeen St Hawkesbury, ON K6A 1K7 Canada
Tel (613) 632-5200

Inventory

Operation Number	Operation	Serial Number	Job	Quantity	Weight	Original Serial Number	Location	Container	Status	Added	Special Comments	Label	Supplier	Change No
Part Number: 8740K75 Revision: PVC Bar, Type 1 Plastic, 4" wide x 1" thick														
100	Receive Ft	S034057	168649	1 ft	0		Start Up Machining		Stock	1/22/2018	Issue Container			
Operation Totals:		1		1	0									
Part Totals:		1		1	0									
Part Number: RBH9928-1-1 Revision: Gage														
150	QC21-SA	S034058	168649	11 Ea	0	S034058	GA	Bin	Stock	1/22/2018	Issue Container			
Operation Totals:		1		11	0									
Part Totals:		1		11	0									
Totals:		2		12	0									

Plex 1/22/2018 3:26 PM Dart.Lajeunesse.Marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					